

Date: Friday, 02/02/2007 9:13:51 AM
 User: Linda Lacelle

Process Sheet











Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3573-9
Job Number : 30587	
Estimate Number : 10804	
P.O. Number :	Part Number : D35739
This Issue : 02/02/2007 S.O. No. :	Drawing Number : W/O 00064
Prsht Rev. : NC	Project Number :
First Issue : / / Type : MACHINED PARTS	Drawing Revision :
Previous Run : 30586	Material :
Written By : <u>WJ</u>	Due Date : 09/02/2007 Qty: 1 Um: Each
Checked & Approved By : <u>WJ</u>	
Comment :	

Additional Product

Job Number:



*No good
Leanne*

Seq. #:	Machine Or Operation:	Description :
1.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		
	Comment: CONVENTIONAL MILLING MACHINE MACHINE PER DRWG D3573 REV.A	
2.0	M6061T6B0500X02500	6061-T6 Bar .50" x 2.5"
		
	Comment: Qty.: 0.0600 f(s)/Unit Total: 0.0600 f(s) 6061-T6 Bar .50" x 2.5" <i>M18530</i>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		
	Comment: PACKAGING RESOURCE #1 ID & STK ATTN: PLEASE PULL MAT'L CERTS GIVE TO PART AND MAT'L CERTS TO LEANNE	

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Drawing Name: D3573-9

Job Number: 30587

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CHARGE TO W/O 00064

CU 0943.15

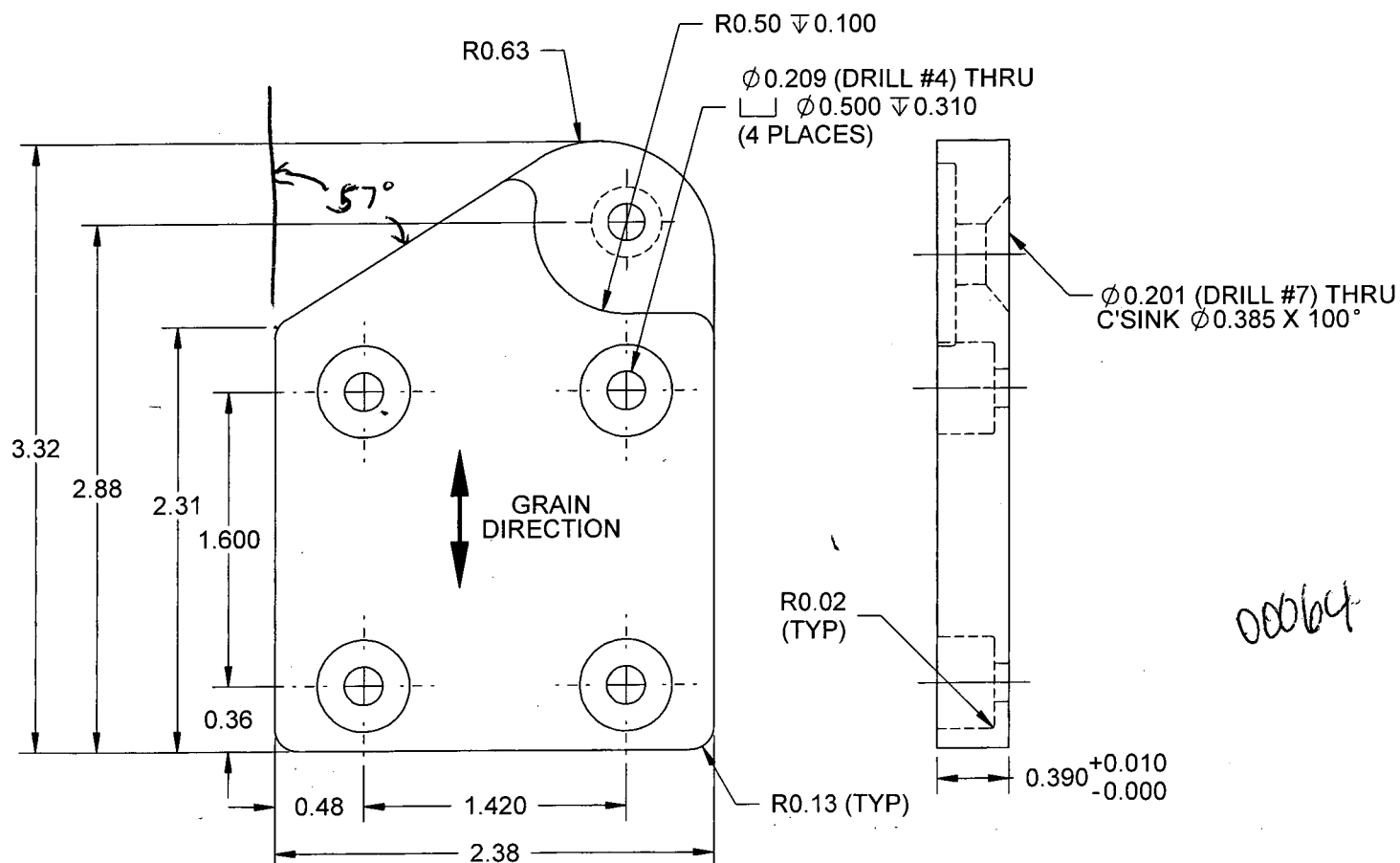
BRETT: PLEASE MAKE 1X D3573-7
1X D3573-9

PRELIMINARY ISSUE

UNDER REVIEW

07.02.01 LE

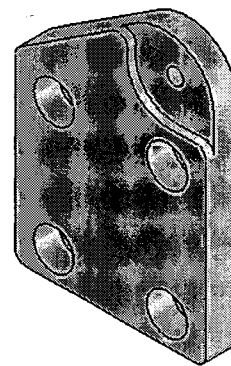
DESIGN LE	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 06.12.07	TITLE ADAPTER		SCALE 1:1



D3573-7 ADAPTER (SHOWN)
(D3573-9 ADAPTER (OPPOSITE))

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-9" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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DART AEROSPACE LTD		Work Order: 30587
Description: ADAPTER		Part Number: D3573-9
Inspection Dwg: D3573, Rev: A		Page 1 of 1

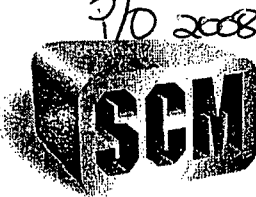
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.63	$\pm .03$.63	✓			
R.50	$\pm .03$.50	✓			
.100	$\pm .010$.101	✓			
$\phi .209$	$\begin{matrix} +.005 \\ -.005 \end{matrix}$.211	✓			
$\phi .500$	$\begin{matrix} +.006 \\ -.001 \end{matrix}$.501	✓			
.310	$\pm .010$.309	✓			
R.13	$\pm .03$.13	✓			
1.420	$\pm .010$	1.420	✓			
2.38	$\pm .030$	2.38	✓			
.48	$\pm .03$.482	✓			
.36	$\pm .03$.361	✓			
3.32	$\pm .03$	3.315	✓			
2.88	$\pm .03$	2.88	✓			
2.31	$\pm .03$	2.31	✓			
$\phi .201$	$\begin{matrix} +.005 \\ -.001 \end{matrix}$.208	✓			
.385 X 100°	$\pm .010$.290	✓			
.390	$\begin{matrix} +.010 \\ -.000 \end{matrix}$.396	✓			

Measured by: <u>EL</u>	Audited by: <u>J.V.</u>	Prototype Approval:
Date: 07-02-03	Date: 07/02/03	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SERVICE CENTER METALS
5850 Quality Way
Prince George, VA 23875

FOR EXTRUDED PRODUCTS

OUR ORDER NUMBER	ITEM
502908	1

BILL TO	MANIFEST NUMBER	DIE NUMBER	DATE OF SHIPMENT
Copper & Brass Sales, Inc.	11532	RB0097	6/27/2005
SHIP TO	CUSTOMER PO	ALLOY / TEMPER	SALESMAN
Copper & Brass Sales, Inc.	CF2113	6061-T6511	R. Randolph Weis
	CUSTOMER PART NUMBER	DESCRIPTION	
	020013-9	SCRB .500x2.500	

CERTIFICATION
ASTM-B221-04a Stencil
SPECIFICATION
AMS-QQA-200/8

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown.

Mechanical Properties

Lot No.	Test No.	Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation
502908-1-1	1	06/20/05	48.2	45.8	16
502908-1-1	50	06/20/05	48.0	45.4	15

SOLD TO Copper & Brass
DATE 9-12-05
CUSTOMER P.O. 2008614
CUSTOMER P/N _____
SHIPPER NO. 226915
QUANTITY 1 PC
BY N. Drueley
COPPER and BRASS SALES INC.

Chemical Composition for Alloy 6061

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	B	Zr	OtherEach	OtherTotal
Min	0.40		0.15		0.8	0.04						
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15			0.05	0.15

Manager of Quality & Technical Services